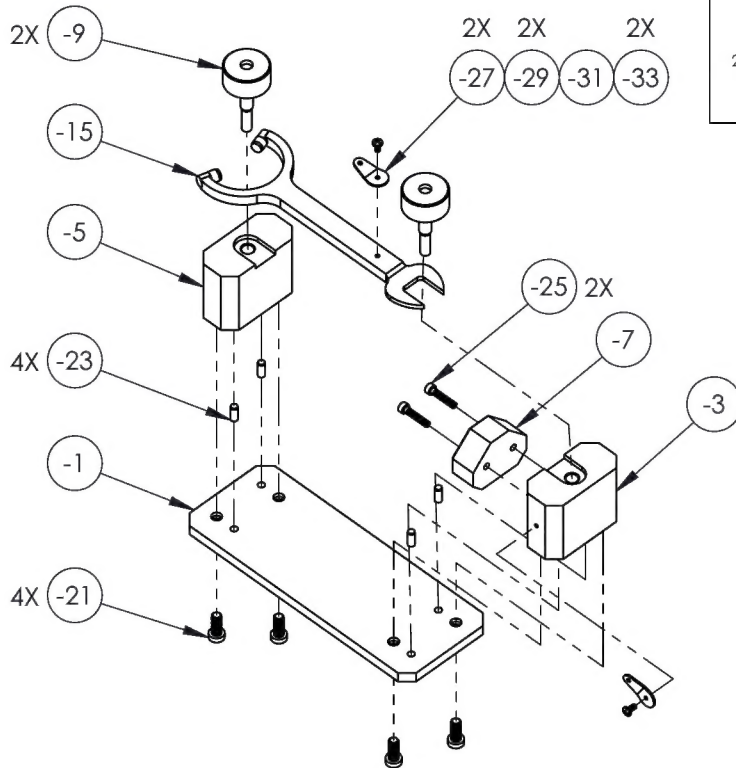
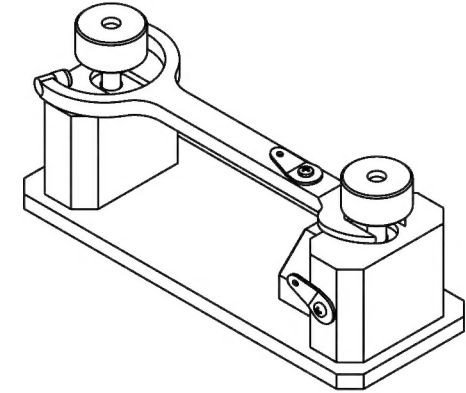


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	7/14/2016	DPD	JAG
2	16-0186	-1 CH'D DIM WAS Ø.394 THRU ALL IS Ø.354 THRU ALL. -9 REMOVED FINISH AND SPEC. -11 CH'D DIM WAS Ø.4005/.3970 THRU ALL S.F. -13 IS Ø.397/.394 THRU ALL (S.F. -13); CH'D MAT'L WAS 1018/1020 CR IS SS303/304; REMOVED FINISH. -13 CH'D DIM WAS Ø.3920/.3898 S.F. -11 IS Ø.3907/.3885 (S.F. -11); ADDED SURFACE FINISH; CH'D MAT'L WAS 1018/1020 CR IS SS 303/304; REMOVED FINISH. -17 CH'D DIM WAS 2X R.35 IS 2X R.15, WAS 2X R.75 IS 2X R.25, WAS 1.70 IS 1.81, WAS .740 IS 1.02, WAS (8.79) IS (8.80); REMOVED DIM 12.945, 13.010; ADDED DIM .880/.872, 2X R1.38, 2X R.50, .76; CH'D MAT'L WAS 1018/1020 CR IS 4140/4142; ADDED HEAT TREAT. -19 ADDED SHEET.	10/21/2016	SM	JAG



UNDER REVIEW

URF 19-928 19.10.23 (VM)

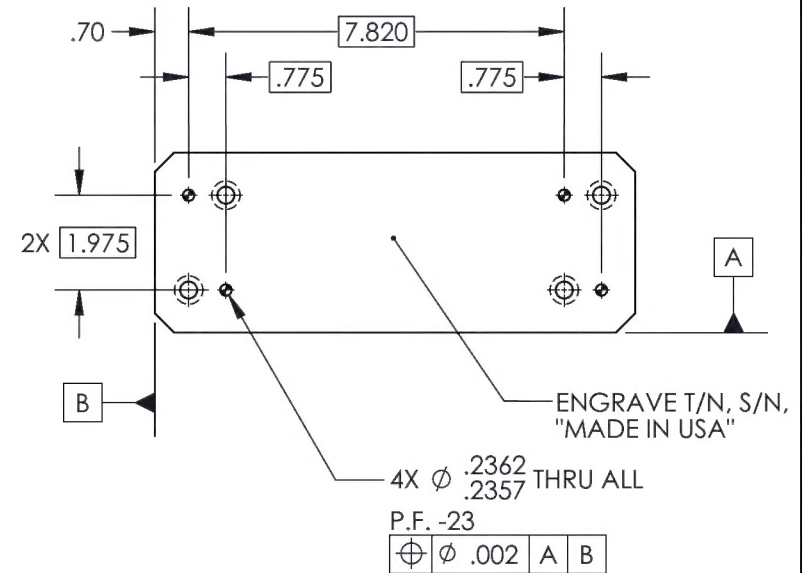
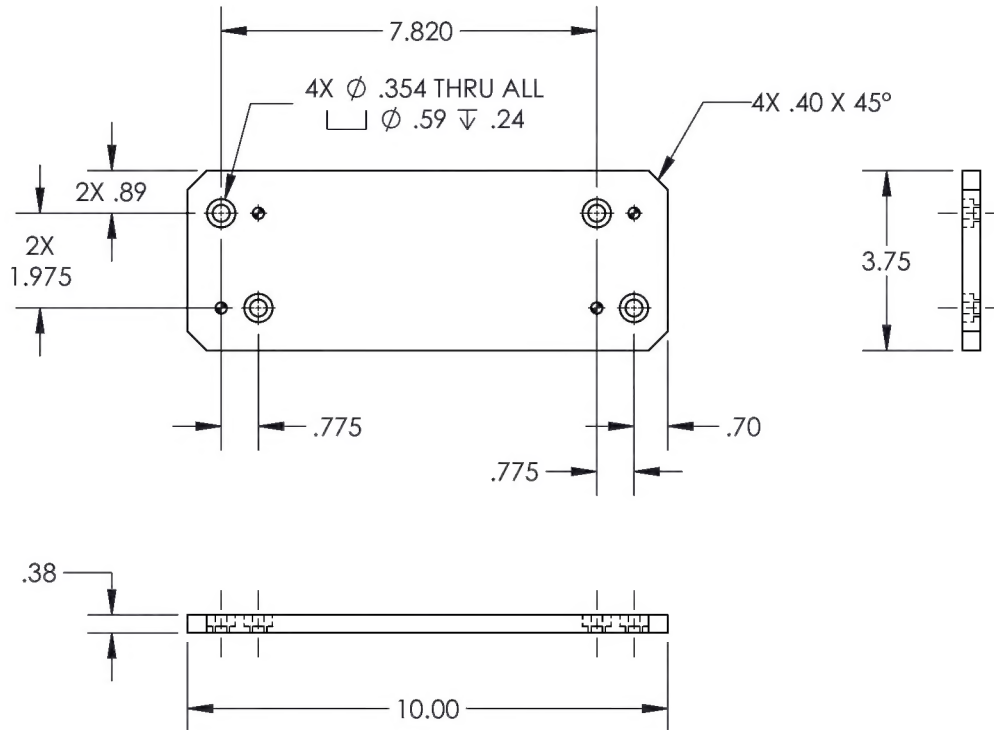
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE PLATE	A36/1018/1020 HR		2
			-3	1	POST	A36/1018/1020 HR		3
			-5	1	POST 2	A36/1018/1020 HR		4
			-7	1	BLOCK	6061		5
	X		-9	2	KNOB WELDMENT			6
	1		-11		KNOB	SS 303/304		7
	1		-13		STUD	SS 303/304		8
X			-15	1	WRENCH WELDMENT			9
1			-17		WRENCH	4140/4142		10
2			-19		DOWEL PIN	STEEL	ØM10 X 20mm (MCMASTER-CARR #91595A640) MODIFIED	11
		B/O	-21	4	SOCKET HEAD CAP SCREW	STEEL	M8 1.25 X 20mm (MCMASTER-CARR #90327A157)	1
		B/O	-23	4	DOWEL PIN	STEEL	Ø6mm X 16mm (MCMASTER-CARR #91595A446)	1
		B/O	-25	2	SOCKET HEAD CAP SCREW	STEEL	M5 X .8 X 25mm (MCMASTER-CARR #90128A249)	1
		B/O	-27	2	CABLE TAB	ALUMINUM	(CARR LANE CL-129-TAB-A)	1
		B/O	-29	2	PAN HEAD SCREW	STEEL	M4 X .7 X 8mm (MCMASTER-CARR #92005A218)	1
		B/O	-31	1	LANYARD	COATED STEEL	Ø1/16 X 16 (CARR LANE #CL-2-C)	N/S
		B/O	-33	2	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896T31)	N/S
ASSY -15	ASSY -9							

NOTE:
REF. AIRBUS T/N M642V4001102.

		TITLE	
		TRH DAMPER SETTING TOOL	
DWG NO.		RBEM642V4001102	
		REV	2
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY:		CLOUGH	
CHECKED:		DUERFELDT	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		GILBERT	
SCALE		1:6	
DATE		4/11/2016	
		SHEET 1 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0186	-1 CH'D DIM WAS Ø.394 THRU ALL IS Ø.354 THRU ALL.	10/21/2016	SM	JAG



UNDER REVIEW
URF 19-928 19.10.23 (VM)

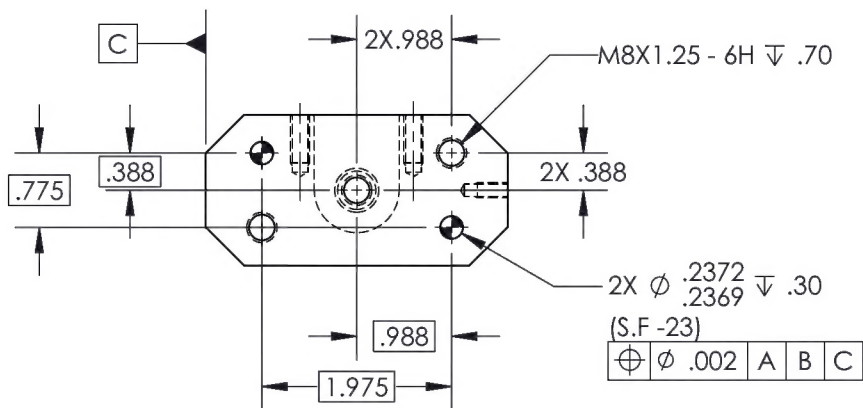
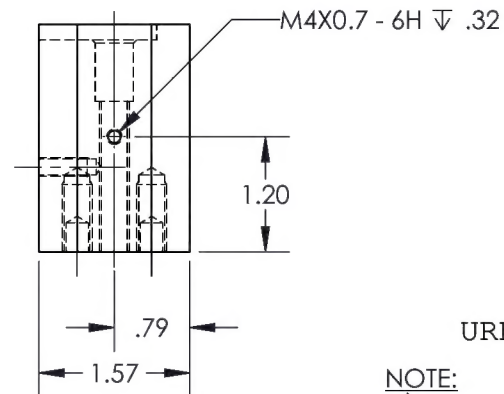
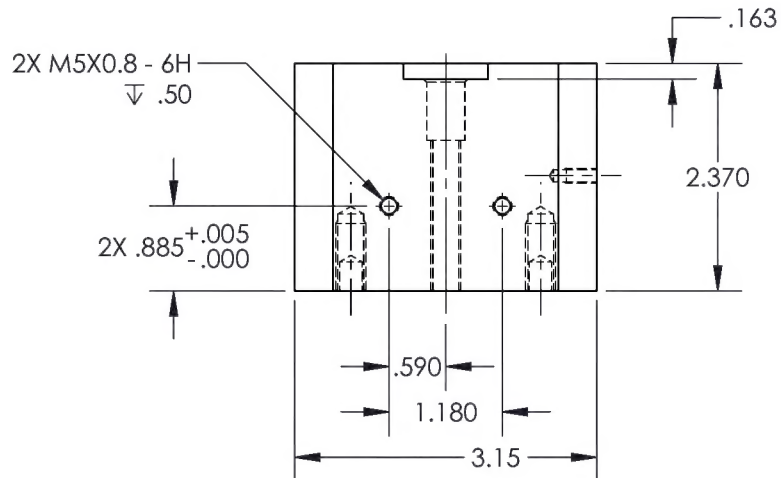
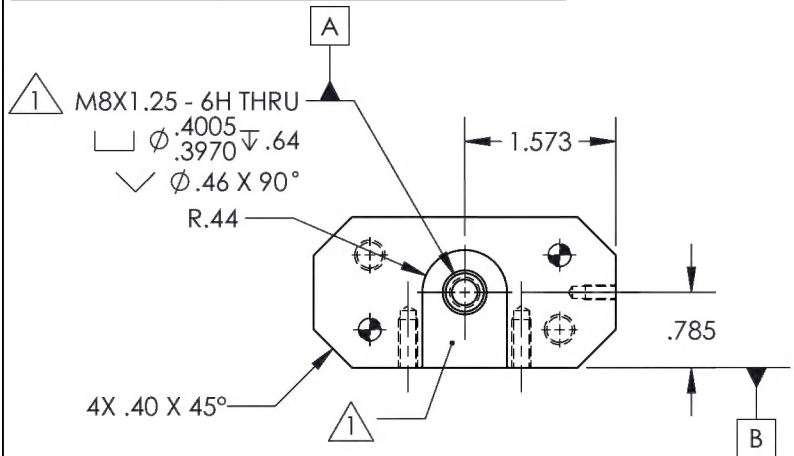
(-1)

BASE PLATE

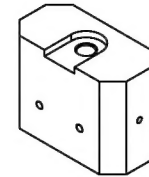
DART AEROSPACE	
TITLE TRH DAMPER SETTING TOOL	
DWG NO. RBEM642V4001102-1	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± .5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:4	DATE 4/11/2016
SHEET 2 OF 11	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



③
 POST



UNDER REVIEW

URF 19-928 19.10.23 (VM)

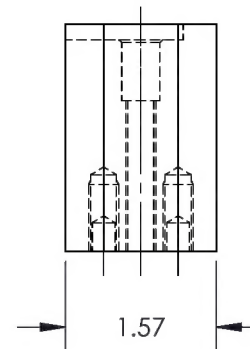
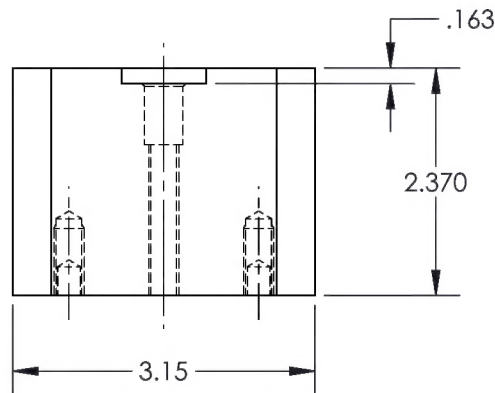
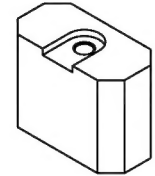
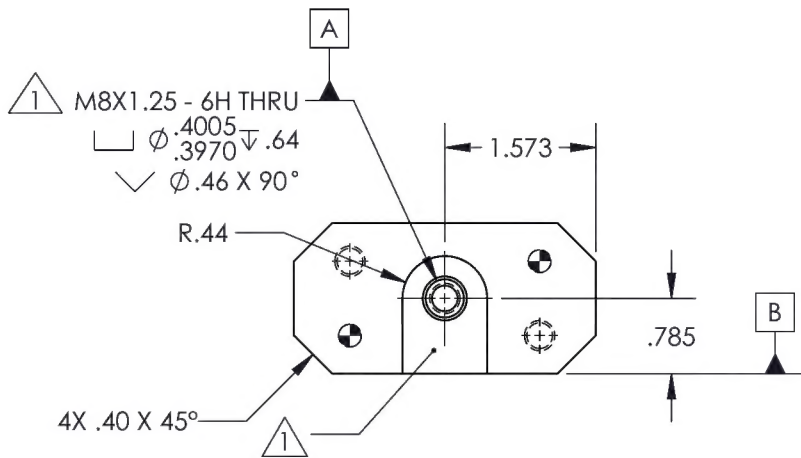
NOTE:

① DEPTH DIMENSIONS FROM THIS SURFACE.

DART AEROSPACE	
TITLE TRH DAMPER SETTING TOOL	
DWG NO. RBEM642V4001102-3	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm .005$ FRACTIONS $\pm 1/8$
FINISH ZINC PLATE	.XX $\pm .01$ ANGLES $\pm 5^\circ$
SPEC ASTM B633 TYPE I SC 2	.X $\pm .1$ SURFACES = 125
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	DATE 4/11/2016
SHEET 3 OF 11	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

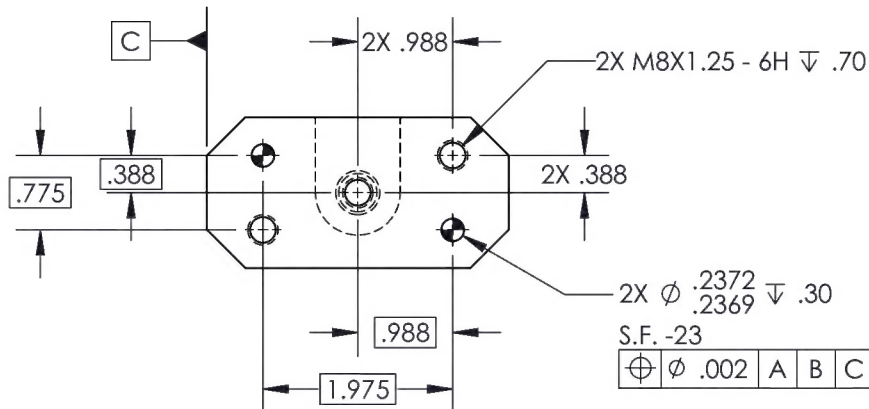


UNDER REVIEW

URF 19-928 19.10.23 (VM)

NOTE:

△ DEPTH DIMENSIONS FROM THIS SURFACE.

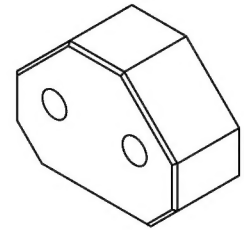
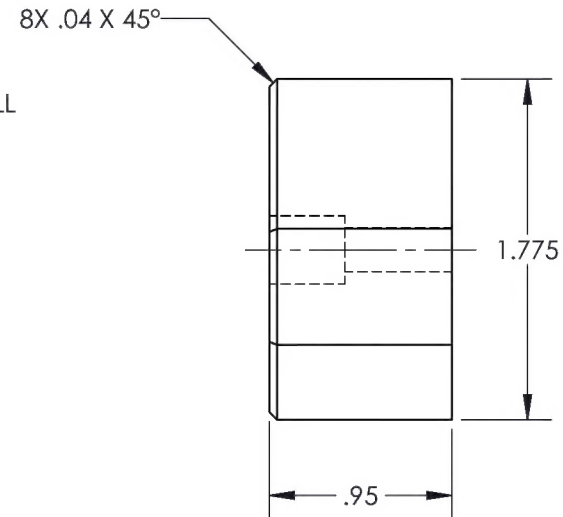
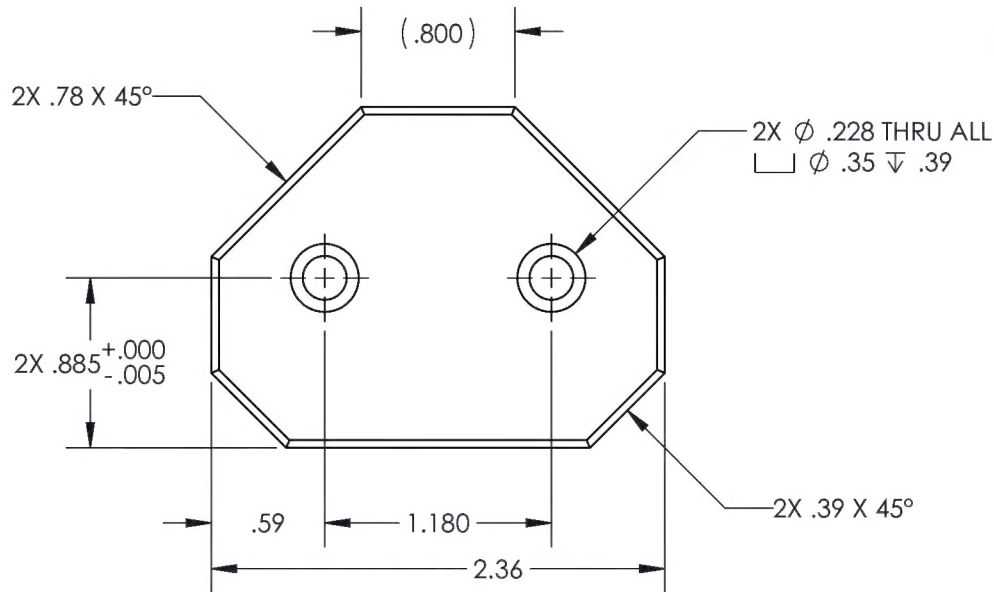


(-5)
POST 2

DART AEROSPACE	
TITLE TRH DAMPER SETTING TOOL	
DWG NO. RBEM642V4001102-5	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 4/11/2016
SHEET 4 OF 11	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



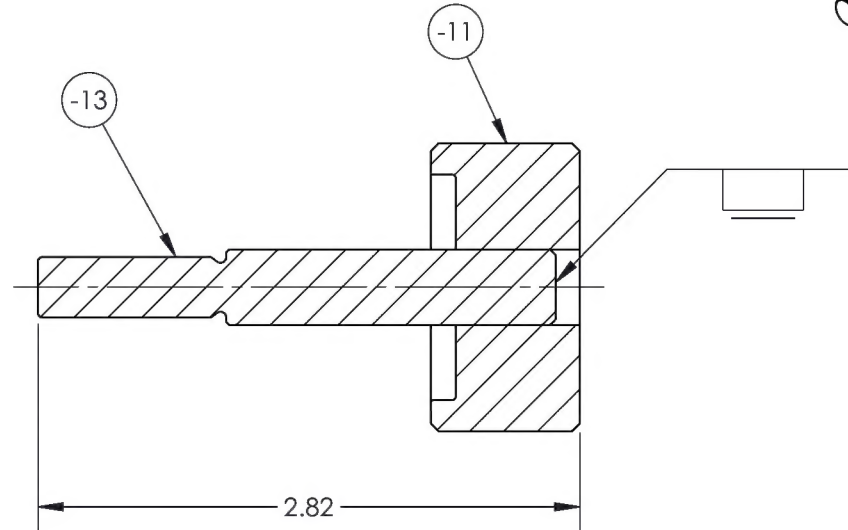
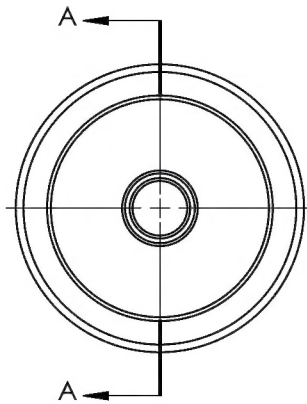
UNDER REVIEW
URF 19-928 19.10.23 (VM)

(-7)
BLOCK

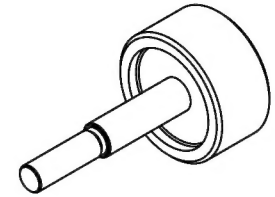
DART AEROSPACE	
TITLE TRH DAMPER SETTING TOOL	
DWG NO. RBEM642V4001102-7	REV 2
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH CLEAR ANODIZE	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS I	.X ± .1 SURFACES = 125
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 4/11/2016
SHEET 5 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0186	-9 REMOVED FINISH AND SPEC.	10/21/2016	SM	JAG



SECTION A-A



UNDER REVIEW

URF 19-928 19.10.23 (VM)

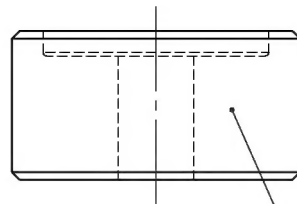
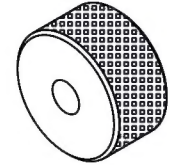
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KNOB WELDMENT

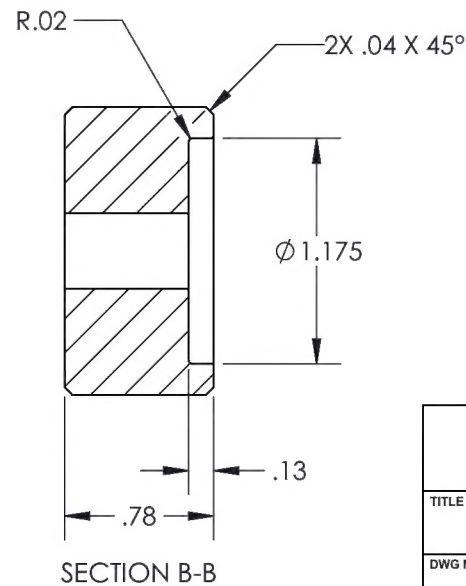
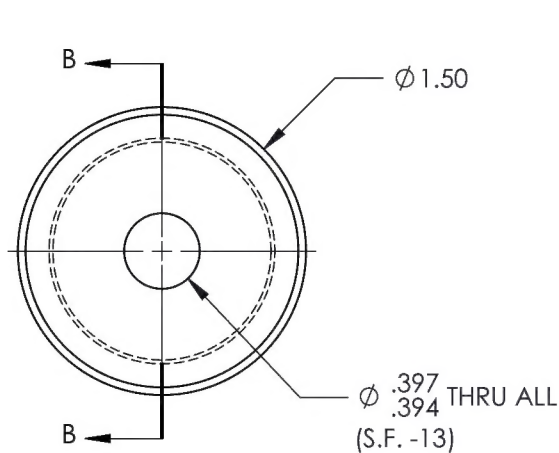
DART AEROSPACE	
TITLE TRH DAMPER SETTING TOOL	
DWG NO. RBEM642V4001102-9	REV 2
MAT'L TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 4/11/2016
SHEET 6 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0186	-11 CH'D DIM WAS Ø.4005/.3970 THRU ALL S.F. -13 IS Ø.397/.394 THRU ALL (S.F. -13); CH'D MAT'L WAS 1018/1020 CR IS SS303/304; REMOVED FINISH.	10/21/2016	SM	JAG



MEDIUM KNURL



SECTION B-B

UNDER REVIEW

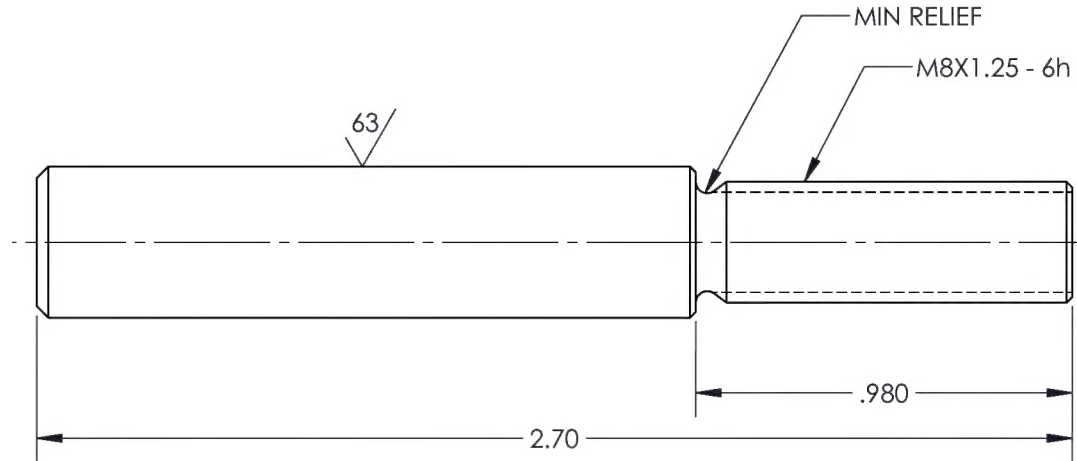
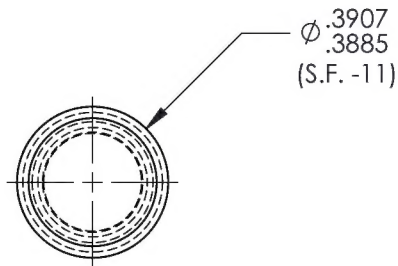
URF 19-928 19.10.23 (VM)

(11)
KNOB

DART AEROSPACE	
TITLE TRH DAMPER SETTING TOOL	
DWG NO. RBEM642V4001102-11	REV 2
MAT'L SS 303/304	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT FINISH	.XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H175
APPROVED: GILBERT	
SCALE 1:1	DATE 4/11/2016
SHEET 7 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0186	-13 CH'D DIM WAS Ø.3920/.3898 S.F. -11 IS Ø.3907/.3885 (S.F. -11); ADDED SURFACE FINISH; CH'D MAT'L WAS 1018/1020 CR IS SS 303/304; REMOVED FINISH.	10/21/2016	SM	JAG



UNDER REVIEW

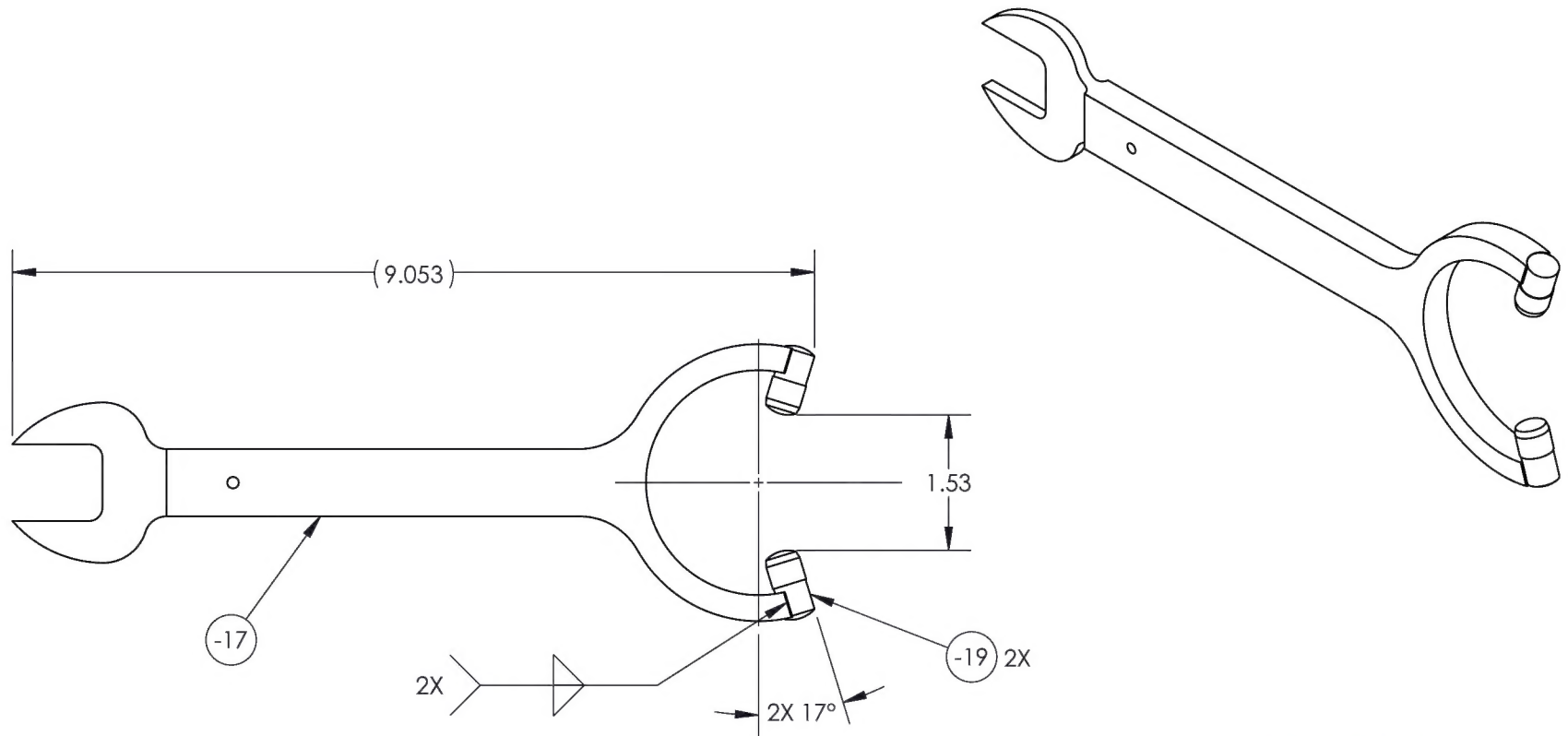
URF 19-928 19.10.23 (VM)

(13)
STUD

DART AEROSPACE	
TITLE TRH DAMPER SETTING TOOL	
DWG NO. RBEM642V4001102-13	REV 2
MAT'L SS 303/304	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125 ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 2:1	DATE 4/11/2016
	SHEET 8 OF 11

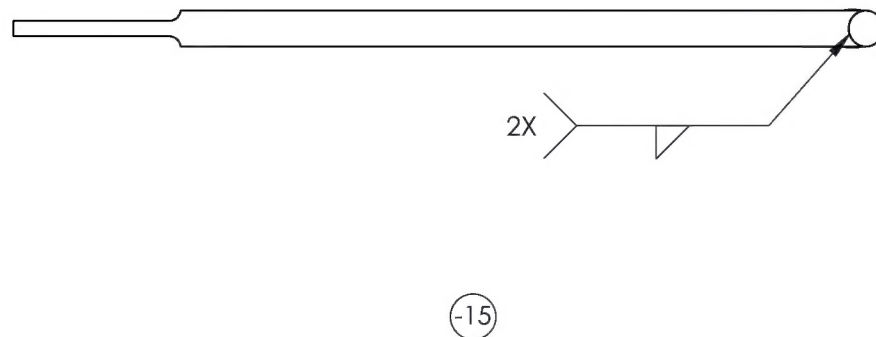
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



UNDER REVIEW

URF 19-928 19.10.23 (VM)

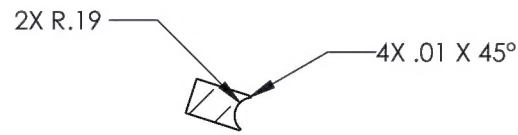
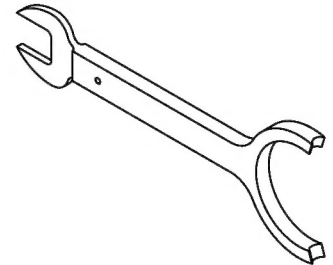
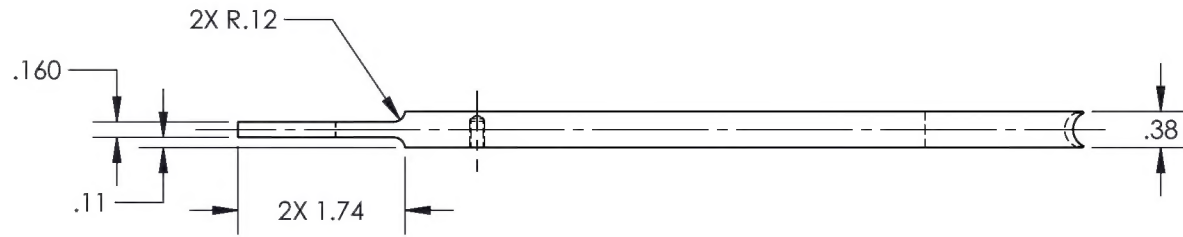


WRENCH WELDMENT

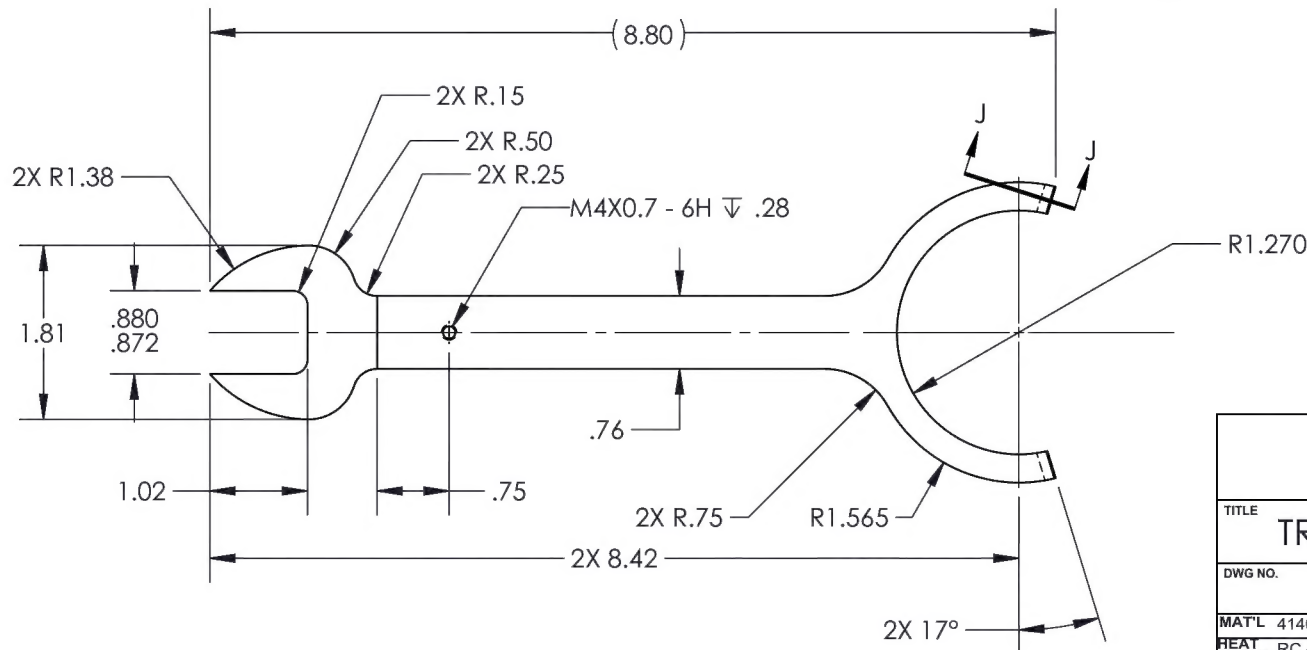
DART AEROSPACE	
TITLE TRH DAMPER SETTING TOOL	
DWG NO. RBEM642V4001102-15	REV 2
MAT'L ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H175
APPROVED: GILBERT	
SCALE 1:2	DATE 4/11/2016
SHEET 9 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0186	-17 CH'D DIM WAS 2X R.35 IS 2X R.15, WAS 2X R.75 IS 2X R.25, WAS 1.70 IS 1.81, WAS .740 IS 1.02, WAS (8.79) IS (8.80); REMOVED DIM 12.945, 13.010; ADDED DIM .880/.872, 2X R1.38, 2X R.50, .76; CH'D MAT'L WAS 1018/1020 CR IS 4140/4142; ADDED HEAT TREAT.	10/21/2016	SM	JAG



SECTION J-J



UNDER REVIEW

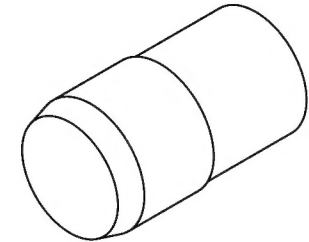
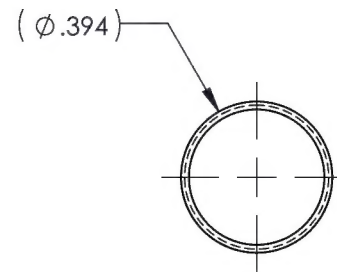
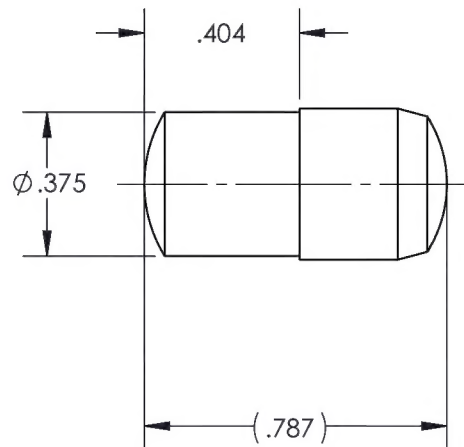
URF 19-928 19.10.23 (VM)

(-17)
WRENCH

DART AEROSPACE	
TITLE TRH DAMPER SETTING TOOL	
DWG NO. RBEM642V4001102-17	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT RC 46-50	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -15	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 4/11/2016
SHEET 10 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0186	-19 ADDED SHEET.	10/21/2016	SM	JAG



UNDER REVIEW

URF 19-928 19.10.23 (VM)

(-19)
DOWEL PIN

DART AEROSPACE	
TITLE TRH DAMPER SETTING TOOL	
DWG NO. RBEM642V4001102-19	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -15	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 2:1	DATE 10/21/2016
	SHEET 11 OF 11